

Work Order ID 80564-1

February-23-12 11:19:01 AM

\*80564\*

Page 1

Item ID: D4092-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Maintenance Step

Start Date: 23/02/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: M.C.S

Date: 2/02/23

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Cut blanks as per folio

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

110

0.00

\*110\*

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA935

Dwg Rev:

Folio rev:

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Accept

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Setup Start \*NS1\*

Revision ID:

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Item Name: Maintenance Step

Start Date: 23/02/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

2 2 3 4

9 8

4

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

ba 12/03/12

9

4

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

9X 4M/12/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Work Order ID 80564

\*80564\*

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February-23-12 11:19:01 AM

Item ID: D4092-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Maintenance Step  
 Start Date: 23/02/2012 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 23/03/2012 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155	Wing Walk as per dwg QS1005 4.4 Batch M12012	0.00							
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*155*									
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HandFinish	Memo	0.00							
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Hand Finishing									
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160	QC3- Inspect Part Finish	0.00							
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*160*									
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QC	Memo	0.00							
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Quality Control									
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170	Identify as per dwg & Stock Location	0.00							
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*170*									
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Packaging	Memo	0.00							
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Packaging									
-----------	--	--	--	--	--	--	--	--	--

x 10 4 Jcl 12/03/13

9 10x 6 m 12/03/14

(9x) Sp 12-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 4

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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/15

P12-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

February-23-12 11:19:04 AM

Page 1

Work Order ID: 80564

\*80564\*

Parent Item: D4092-1

\*D4092-1\*

Parent Item Name: Maintenance Step

Start Date: 23/02/2012

Required Date: 23/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD  
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108		Manufactured	No			100	f	63.1438	2.5	52.63158			

\*D2761-108\*

\*\*

Extrusion (HPK)

Location

Loc Qty

Loc Code

MAT007

63.1438

8323

63.1438

28.94736 25 12-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

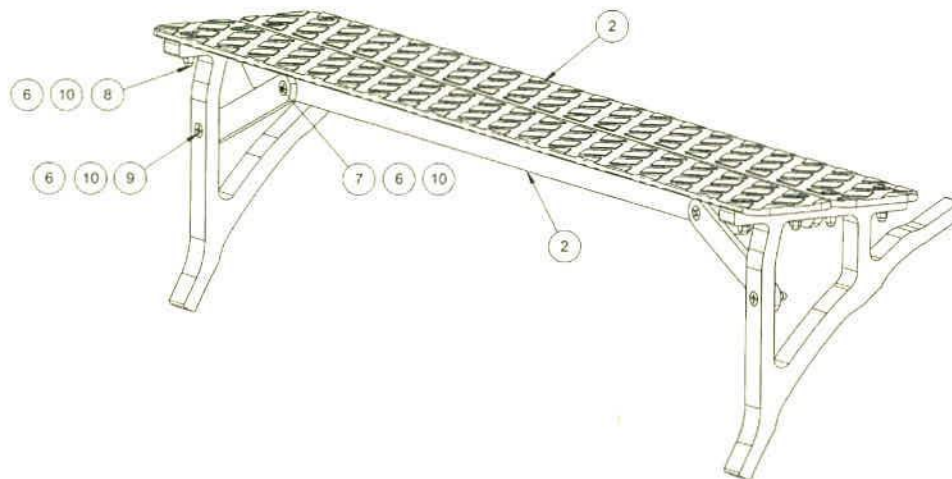
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4092-042 MAINTENANCE STEP ASSEMBLY**

B

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

**RELEASED**  
2011-09-*JND*

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4092</b>	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE <b>MAINTENANCE STEP ASSY</b>	SCALE NTS
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DATE	<b>11.07.27</b>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

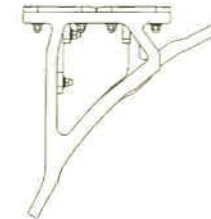
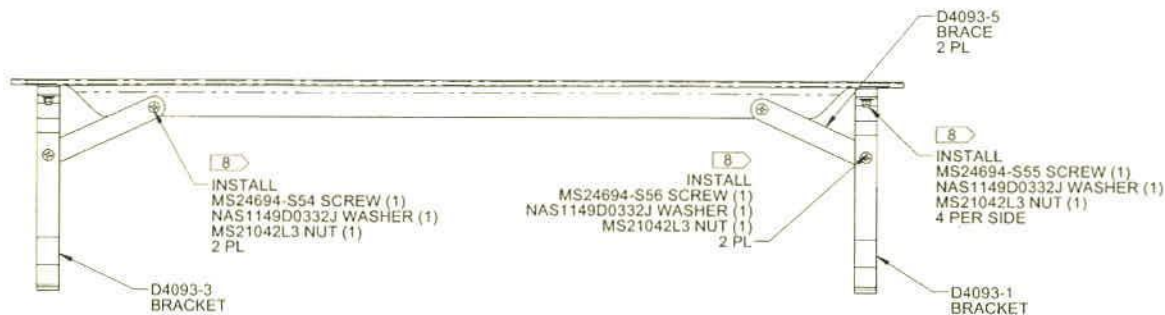
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



80564



# D4092-041 MAINTENANCE STEP ASSEMBLY

RELEASED  
2011-09-22

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	9/1	D4092	SHEET 3 OF 6
APPROVED	140	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

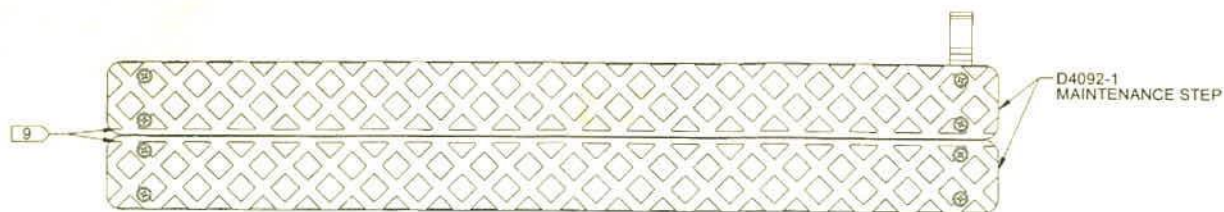
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





D4092-1  
MAINTENANCE STEP



8  
INSTALL  
MS24694-S54 SCREW (1)  
NAS1149D0322J WASHER (1)  
MS21042L3 NUT (1)  
2 PL

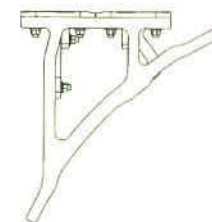
8  
INSTALL  
MS24694-S56 SCREW (1)  
NAS1149D0322J WASHER (1)  
MS21042L3 NUT (1)  
2 PL

D4093-5  
BRACE  
2 PL

8  
INSTALL  
MS24694-S55 SCREW (1)  
NAS1149D0322J WASHER (1)  
MS21042L3 NUT (1)  
4 PL PER SIDE

D4093-1  
BRACKET

D4093-3  
BRACKET



RELEASED  
2011-09-22  
MMO

# D4092-042 MAINTENANCE STEP ASSEMBLY

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 4 OF 6
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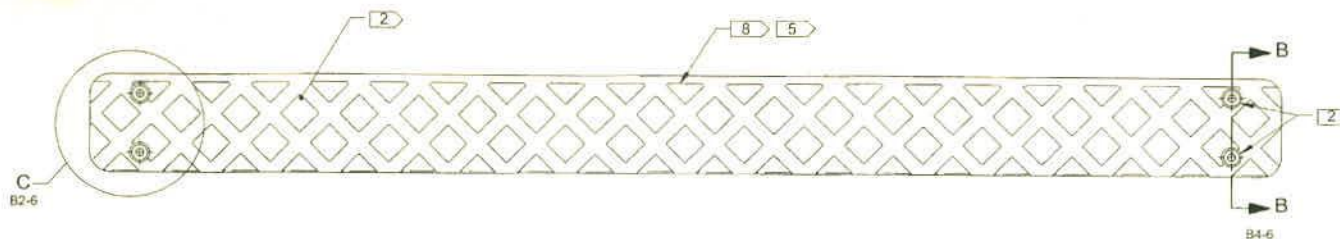
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

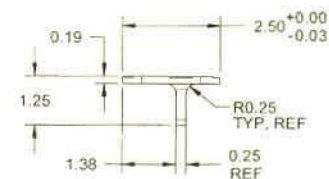
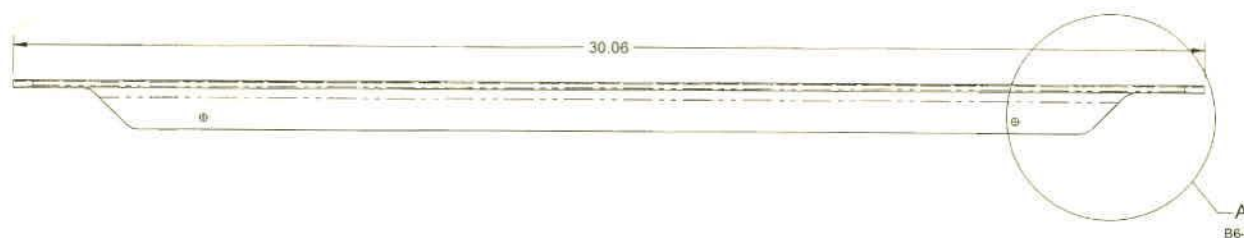
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80564



**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JW

**NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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MFG. APPR.	91	D4092	SHEET 5 OF 6
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DE APPR.	91	MAINTENANCE STEP ASS'Y	NTS
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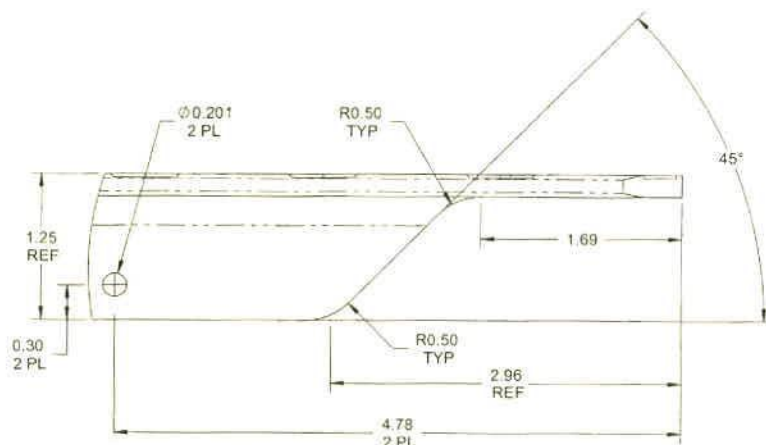
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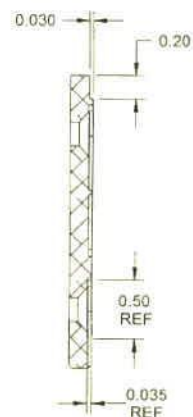




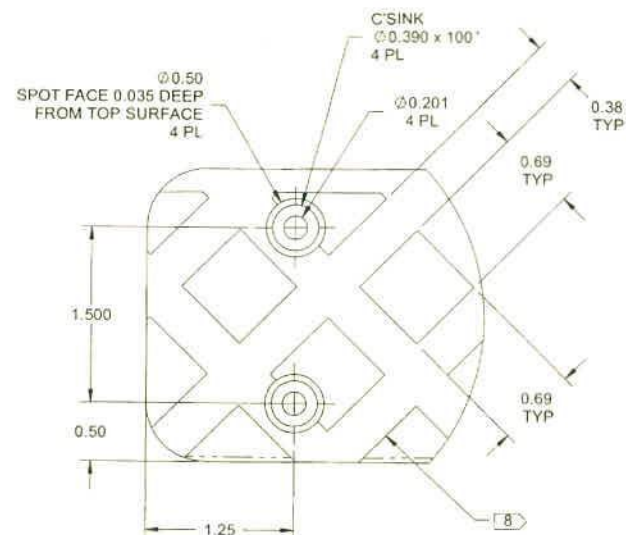
80564



DETAIL A  
SCALE 3X, TYP



SECTION B-B  
SCALE 3X, TYP



DETAIL C  
SCALE 3X, TYP

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2011-09-22

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MFG. APPR.	<i>RF</i>	D4092	SHEET 6 OF 6
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